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(71) Applicant: **RESEARCH LABORATORIES OF AUSTRALIA PTY LTD [AU/AU]; 210 Greenhill Road, Eastwood, S.A. 5063 (AU).**

(72) Inventor: **MARKO, Herbert, Lee; 50 Warren Road, Para Vista, S.A. 5093 (AU).**

(74) Agent: **MADDERNS; 1st Floor Wolf Blass House, 64 Hindmarsh Square, Adelaide, S.A. 5000 (AU).**

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(54) Title: **LIQUID TONER COMPOSITION**

(57) Abstract: A liquid toner composition for use in high viscosity electrostatic printing processes. The liquid toner comprises a non-aqueous carrier liquid which is an electrically non-conductive liquid being a silicone fluid of straight chained or cyclic configuration, a silicone fluid of cyclic configuration, a silicone fluid of branched configuration, or a combination thereof having a viscosity in the range of from 0.5 to 1,000mP.a.s, an insoluble marking particle, and a dispersion additive, the dispersion additive comprising a polysiloxane having at least one functional group comprising a radical which introduces an active site into the polysiloxane and wherein the functional group is a radical selected from the group comprising a vinyl group, a carboxylic group, a hydroxyl group, or an amine group. The particular advantage of the liquid composition is that the formation of rivulets is minimised, during printing with resultant improvement in image quality.

**TITLE: LIQUID TONER COMPOSITION****FIELD OF THE INVENTION**

This invention relates to liquid compositions suitable as toners and inks for non-  
5 impact printing.

**BACKGROUND OF THE INVENTION**

It has been recognised that certain properties of carrier fluids for liquid  
developers are required for effective functioning in conventional  
electrostatographic liquid development processes. Many of the physical  
10 requirements are mandatory, as known by those skilled in the art, but there are  
also other considerations, such as low toxicity, fire safety, low solvent power,  
low odour etc. For these reasons, isoparaffinic- hydrocarbons such as the  
Isopar range manufactured by Exxon Corporation, the Shellsol range  
manufactured by Shell Chemical and the Soltrol range manufactured by Phillips  
15 Petroleum became the industry standards for liquid toner carriers.

In more recent times, however, increased environmental concerns have placed  
liquid development processes under increasing pressure to further reduce or  
eliminate volatile emissions.

Other carrier materials applicable to liquid developers have been investigated  
20 and of these, silicone fluids are clearly liquids which combine all previously and  
currently desired properties of a modern liquid toner carrier.

In general, a liquid toner for developing electrostatic images is prepared by  
dispersing an inorganic or organic colorant such as iron oxide, carbon black,  
nigrosine, phthalocyanine blue, benzidine yellow, quinacridone pink and the like

into a liquid vehicle which may contain dissolved or dispersed therein synthetic or naturally occurring polymers such as acrylics and their copolymers, alkyds, rosins, rosin esters, epoxies, polyvinyl acetate, styrene-butadiene, cyclised rubber, ethylene vinyl acetate copolymers, polyethylene, etc. Additionally, to 5 impart or enhance an electrostatic charge on such dispersed particles, additives known as charge directors or charge control agents may be included. Such materials can be metallic soaps, fatty acids, lecithin, and the like.

Similarly an area of great interest exists in the development of liquid compositions for ink jet printing processes that employ environmentally friendly 10 fluids as the carrier liquid. There are problems, however, with dispersion of marking particles such as organic pigments into such carrier liquids.

Silicone fluids have been used as carriers for liquid toners, eg. in U.S. Pat. No. 3,105,821 to S. W. Johnson, and U.S. Pat. No. 3,053,688 to H.G. Greig. Both of these early patents recognised the virtues of silicone fluids, but the 15 understanding of the functioning of liquid toners at that time was relatively empirical, with those patents teaching simply the mechanical dispersion of a dry toner into the silicone fluid with no regard to chemical compatibility, which in turn governs the final particle size and stability of the dispersion so produced. More recently silicone fluids have again been recognised as desirable carrier 20 fluids for liquid toners.

However, in the above application reliance is also placed on mechanical dispersion only. It is well known that silicone fluids have low solvent power for plastics and this property is well suited for copy machine components and organic photoconductor life. An unfortunate corollary to this is that many 25 dispersion agents normally used in liquid toners, are incompatible with silicone fluids.

U.S. Pat. No. 5,612,162 to Lawson et al, as well as U.S. Pat. No. 5,591,557 to Lawson et al disclose compositions and methods of forming a liquid developer

in silicone fluid. The teachings of these patents and formulations therein suffer from inadequate dispersion quality as required by high quality electrostatic printing. In particular, silicone fluid compatible dispersing agents are not employed in these formulations and consequently rivulet formation is a problem

5 not addressed by these patents; such rivulets are manifest as disruptive localised areas of the continuous image and are similar to patterns observed when a high viscosity material is applied to flat surfaces as a thin film by means of a roller applicator.

It has been found that the particle size obtainable and the stability of

10 dispersions of the prior art, have been inadequate due to the inability of the silicone fluid to fully disperse the marking particles sufficiently to achieve and maintain the required particle size during manufacture and use.

To further alleviate the environmental concerns as disclosed earlier, the concept of using high viscosity carrier fluids and or high solids content of the marking

15 particles as liquid developers has been proposed. This type of liquid toner can develop an electrostatic latent image by use of a thin film of such highly concentrated liquid toners, within a process whereby these toners adhere selectively to the image part of an electrostatic latent image on an image bearing member without the toner adhering to the non-image part. This liquid

20 developing method occurs by preferential adherence to the electrostatic latent image carrier surface under the dominant influence of the electric field strength of the electrostatic latent image, the quantity of toner transferred being proportional to the relative incremental field strength of the latent electrostatic image. This is a very high speed development method, in comparison to

25 conventional liquid development which is solely reliant on electrophoretic migration along relatively large development gaps. An electrostatic printer utilising this type of high viscosity toner is described in Patent specification WO95/08792. With this concept however, a number of problems arise in relation to the liquid developer in such printing systems.

Such problems as the dispersion quality of the marking particles are apparent in printed copies from such non-impact printing devices using such liquid developers and are manifest as characters or areas of low optical density or poorly defined resolution with between such characters excessive background 5 fog or background noise. The low optical density in many cases is related to the formation of so called rivulets.

This invention proposes an improvement in the dispersion quality of the marking particles thereby alleviating the problems noted above. In particular the problem of rivulet formation which is thought to be caused by the inadequate 10 dispersion of marking particles such as pigments in a liquid developer is alleviated.

Such rivulet formation as so described can be readily seen in prints from a non-impact printing device such as an electrostatic printer of the type described in Patent specification WO95/08792. Although it must also be understood that 15 such rivulet formation has been seen to detract from prints from other printing devices.

Thus the need exists for a method of minimising this rivulet formation by the inclusion of appropriate dispersion additives into preferred, high viscosity, high solids content liquid developers comprising liquid carriers which meet modern 20 environmental demands and produce high quality prints with improved image resolution and higher optical density through the action of maintaining improved dispersion quality of the marking particles within the carrier liquid.

It is the object of this invention therefore, to provide an improved liquid toner composition which has additives which result in improved dispersion quality and 25 thereby eliminating the formation of rivulets.

It is a further object of this invention to provide a liquid toner composition which has additives which result in improved particle size distribution, due to improved

dispersion, as a result of increased steric stabilisation of the marking particles during manufacture, therefore inhibiting agglomeration during manufacture and for the life of the liquid developer.

It is a further object of this invention to provide a liquid toner composition which

5 has additives which result in improved stability over a range of climatic conditions, and therefore having greatly improved shelf-life.

The liquid toner composition of this invention may be an ink for use in inkjet type printers, it may be a toner or liquid developer for electrostatography.

#### BRIEF DESCRIPTION OF THE INVENTION

10 In one form therefore the invention is said to reside in a liquid toner composition for use in electrostatic printing processes operating within the viscosity range of from 100 to 10,000 mPa.s,  
the liquid toner comprising;

(a) a non-aqueous carrier liquid, the carrier liquid being an electrically non-conductive liquid selected from the group comprising a silicone fluid of straight chained configuration, a silicone fluid of cyclic configuration, a silicone fluid of branched configuration, or a combination thereof having a viscosity in the range of from 0.5 to 1,000 mPa.s.

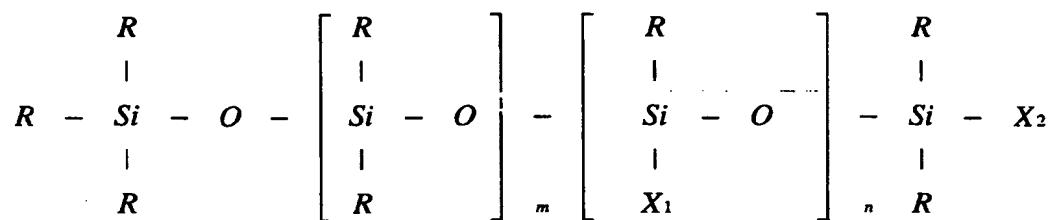
(b) an insoluble marking particle, and

15 (c) a dispersion additive, the dispersion additive comprising a polysiloxane having at least one functional group comprising a radical which introduces an active site into the polysiloxane and wherein the functional group is a radical selected from the group comprising a vinyl group, a carboxylic group, a hydroxyl group, or an amine group,

20 whereby the formation of rivulets is minimised during printing with resultant improvement in image quality.

Preferably the polysiloxane dispersion agent is selected from the group comprising a straight chain polysiloxane or a cyclic polysiloxane or a branched polysiloxane, or a combination thereof. The viscosity of the polysiloxane dispersion additive may be up to 90,000 mPa.s.

5 The polysiloxane dispersion agent may be a polysiloxane polymer represented by the following general structure:



where R represents an alkyl ( -CH<sub>3</sub>) group or a hydroxyl group ( -OH) and X<sub>1</sub> and X<sub>2</sub> represent functional groups with:

10 (1) Amine functionality ( -NH<sub>2</sub>)

(2) Carboxylic acid functionality ( -COOH)

(3) Vinyl functionality ( -CH=CH<sub>2</sub>)

(4) Hydroxyl functionality ( -OH)

(5) Alkyl functionality ( -CH<sub>3</sub>), but wherein either X<sub>1</sub> or X<sub>2</sub> also contains a functionality selected from (1) to (4) above.

15 (6) An alkyl group containing a functional group selected from (1) to (4) above, with appropriate stoichiometry, ie:

-RX

-RXR

-RXRX

-XR

-XRX

-XRXR

5 where X is a functional group selected from (1) to (4) above and R is an alkyl group.

The marking particle may be selected from the group comprising a pigment, a polymeric resin, ferromagnetic particles and luminescent particles and the marking particle concentration may be up to 40% by weight. The insoluble 10 marking particle may be a modified epoxy polymer, the polymer being a reaction product of an epoxy resin and nitrogen bearing polymeric compound. The nitrogen bearing polymeric compound may be an alkylated polyvinylpyrrolidone.

Where the marking particle is a pigment the marking particle may be coated 15 with the modified epoxy polymer.

Preferably the modified epoxy polymer is blended with a pigment and then extruded.

The liquid composition according to this invention may further include one or more additional components selected from the group comprising dyestuffs, 20 curing agents, bacteriostats, charge control agents and anti-oxidants.

#### DETAILED DESCRIPTION OF THE INVENTION

We have found that improved print performance can be achieved with the dispersion agent of the present invention. Particularly, high viscosity silicone

fluid carrier liquids often possess inherent problems and it has been found that the incorporation of the dispersion agent of the present invention has provided improvements which include rivulet formation on the printed images being greatly reduced, dispersion quality being greatly improved, liquid is not 5 abstracted from the marking particles in the dispersions, image density is greatly increased and smoothness of image is improved.

One explanation for the improvements of the type discussed above, to which the applicants do not wish to be bound, is that the active sites provided by the functional groups of the polymeric polysiloxane dispersion additives may bind or 10 adsorb to the surface of the marking particles thereby providing the particles with an external physical polymeric barrier or so-called "tail" that is carrier fluid compatible thereby preventing agglomeration of the particles through the mechanism of steric stabilisation, resulting in improved dispersion and consequently giving the improvements discussed above. It is also believed that 15 the dispersion additives of the present invention may contribute to increasing the ionic stabilisation of the marking particles by effectively increasing the charge repulsion between particles.

We have found that greatly improved print performance can be achieved with the dispersion agent of the present invention with liquid compositions 20 comprising a silicone fluid carrier with a viscosity in the order of 0.5-1,000 mPa.s., preferably 20-500 mPa.s. The concentration of the marking particles within the liquid developer can be up to 40% by weight, preferably 10-25%. Such a liquid developer may exhibit a viscosity in the order of 100-10,000 mPa.s, preferably 200-1,000mPa.s.

25 In particular, compositions with a high concentration of marking particles in a silicone fluid, were found to achieve good print performance in an electrostatic printer in comparison to compositions without the dispersion agent. It has been found that the incorporation of the dispersion agent of the present invention has provided further improvements which include rivulet formation on the printed

images being greatly reduced, dispersion quality being greatly improved, liquid is not abstracted from the marking particles in the dispersions, image density is greatly increased and smoothness of image improved.

An additional benefit was found that the average particle size distribution of the

5 liquid developers are also effectively reduced indicating the achievement of more efficient dispersion and therefore milling of the marking particles during manufacture. The dispersion additive further acts to greatly reduce the re-agglomeration of particles after milling by providing the dispersion with sufficient steric stabilisation to maintain an optimised liquid developer.

10 The dispersing agent may be incorporated into the liquid composition by techniques commonly employed in the manufacture of liquid compositions such as: ball-jar milling, attritor milling, bead milling etc. Pre-mixing techniques involving blending the dispersion agent into the carrier liquid before the addition of marking particles and before the milling stage can also be used to

15 incorporate the dispersion additive into the liquid developer formulation.

The dispersion additive also effectively improves dispersion quality for liquid developers manufactured by non-milling / grinding techniques, such as a liquid developers produced by hot melt emulsification (US Patent No. 5,609,979, Spheroidal Particles Useful for Electrostatography by T. M. Lawson).

20 This then generally describes the invention but to assist with understanding reference will now be made to a number of examples and comparisons which show the efficacy of the dispersion agent of the present invention in a variety of compositions.

25 The various examples were tested using an electrostatic printer of the type described in Patent specification WO95/08792.

#### COMPARISONS AND EXAMPLES

The following comparisons and examples are presented to define the invention more fully without any intention of being limited thereby. The following formulations may include a charge director. Charge directors as known to those skilled in the art can be added to impart a charge on the marking particles as required. All formulation examples listed below were prepared by adding the constituents of each example into a ceramic ball jar containing spherical ceramic grinding media and milling for 4 days to prepare a resinous toner. It should be understood that the quantities of raw materials in the Examples can be varied dependent on the liquid developer characteristics required and the mode of operation of the electrostatic printer. The formulations were then examined for print quality by producing images with the electrostatic printer as discussed above.

#### COMPARISON 1

15	Araldite 6084	crushed	96g
	Irgalite Blue LGLD		24g
	Nuxtra 6% Zirconium		6g
	DC 200 Fluid	20cSt	474g

#### EXAMPLE 1

20	Araldite 6084	crushed	96g
	Irgalite Blue LGLD		24g
	Nuxtra 6% Zirconium		6g
	Elastosil M4640A		60g
25	DC 200 Fluid	20cSt	414g

#### EXAMPLE 2

Araldite 6084	crushed	96g
Irgalite Blue LGLD		24g

11

Nuxtra 6% Zirconium	6g
Elastosil M4640A	150g
DC 200 Fluid	20cSt 324g

## COMPARISON 2

5

Araldite 6084	crushed	96g
Irgalite Blue LGLD		24g
Nuxtra 6% Zirconium		6g
DC 345 Fluid		474g

## 10 EXAMPLE 3

Araldite 6084	crushed	96g
Irgalite Blue LGLD		24g
Nuxtra 6% Zirconium		6g
Elastosil M4640A		60g
DC 345 Fluid		414g

## EXAMPLE 4

Araldite 6084	crushed	96g
Irgalite Blue LGLD		24g
Nuxtra 6% Zirconium		6g
Elastosil M4640A		150g
DC 345 Fluid		324g

20 Elasiosil M4640A is a polysiloxane having a vinyl functional group made by Wacker Chemicals, Munich Germany. Araldite 6084 is an epoxy resin made by Ciba-Geigy, Basel Switzerland. Irgalite Blue LGLD is a CI Pigment Blue 15:3 made by Ciba-Geigy, Basel Switzerland. Nuxtra 6% Zirconium is a zirconium octoate made by Creanova, New Jersey U.S.A.. DC200 20cSt Fluid and

**DC345 Fluid are silicone oils made by Dow Corning, U.S.A**

For each of the examples standard test prints were prepared. Optical density measurements were taken with a Gretag, D186 densitometer. Measurements of the average maximum optical density in 100% solid image areas and also an 5 average background (background fog or noise) optical density for all examples were taken and the overall image quality was also evaluated.

Comparison 1 and Example 1 and Example 2 demonstrated the beneficial effect of one of the preferred dispersion agents. The carrier liquid employed in these formulations is a Dow Corning silicone fluid known as DC 200 20cSt fluid. The 10 image quality of these prints was greatly improved as the quantity of dispersion agent was increased. In summary, as the amount of dispersion agent increases in this formulation series, ie Comparison 1 to Example 1 to Example 2, the following trends were noticed:

- Rivulet formation is greatly reduced
- 15 - Optical image density is greatly increased
- Overall image smoothness is greatly improved

Comparison 2 and Example 3 and Example 4, formulations employing the non-volatile cyclic silicone fluid carrier liquid DC345 fluid, demonstrated the same trend as explained above.

20 The effectiveness of the dispersion agent in different carrier fluids has been illustrated with Examples 1 – 4. However, in these print sample there was an observable trend of increased background fog or noise with increased dispersion agent concentration. This effect can be attributed to the higher dispersion quality achieved with increasing dispersion agent; for as dispersion 25 quality increases, particle size and agglomeration tendency decreases, resulting in a substantial population of toner "fines" (primarily pigment fines) being

available for development in the background areas.

Consequently, a method to eliminate background fog with the improved dispersion quality liquid compositions has been developed. As the fines are primarily pigment, this can be overcome by resin coating the pigment surface,

5 by extruding (or other techniques known to the art of resin coating pigment) the pigment and resin together (to produce Extrudate 1) prior to adding them to the ball jar for milling.

#### Extrudate 1

	Araldite 6084	80g
10	Irgalite Blue LGD	20g

The formulation example listed below demonstrates the effectiveness of this technique and was prepared by adding the constituents of the example (Example 11) into a ceramic ball jar containing spherical ceramic grinding media and milling for 7 days to prepare a resinous toner. The formulation was then

15 examined for print quality by producing an image with the electrostatic printer as discussed above.

#### EXAMPLE 5

	Extrudate 1	125g	
	Finish WR1101	5g	
20	DC 200 Fluid	100 cSt	370g

Finish WR1101 is a polysiloxane having an amine functional group, made by Wacker Chemicals, Munich Germany. DC 200 100cSt Fluid is a silicone fluid made by Dow Corning, U.S.A..

With the above example 5, it was surprisingly found that the use of Finish

25 WR1101 contributed so significantly to marking particle charging that the use of

an additional charge control agent was not required.

Furthermore, the dispersion strength of the Finish WR1101 was found to be superior to that of the previously used Elastosil M4640A and it could therefore be used in far lesser quantities while still maintaining the desirable dispersion

5 attributes of these materials.

The improvement in dispersion strength is believed to be due to the increased surface activity associated with the amine functional Finish WR1101 compared to that of the vinyl functional Elastosil M4640A.

The results of this formulation showed that resin coating the pigment has 10 resulted in maintaining the improved image quality effects associated with the dispersion additive, while also eliminating any background density. The overall print quality results could be summarised as follows:

- Rivulet formation was greatly reduced.
- Optical image density was greatly increased.
- 15 - Overall image smoothness was greatly improved.
- Background image density was eliminated.

Use of the dispersion additive is not restricted to epoxy resin based systems. Dispersion quality and therefore image quality is greatly improved with the addition of these dispersion additives to either pigment / resin extruded or un- 20 extruded formulations which employ other synthetic or naturally occurring polymers such as, acrylics, polyesters, and their copolymers, alkyds, rosins, rosin esters, other epoxies or modified epoxies, polyvinyl acetate, styrene-butadiene, cyclised rubber, ethylene vinyl acetate copolymers, polyethylene etc.

In fact, a preferred embodiment consists of an extruded, pigment – modified

epoxy formulation. The epoxy resin is modified by reacting it with an alkylated polyvinylpyrrolidone to produce a new thermoplastic resin which is then extruded with the pigment. For convenience we can label this modified epoxy resin coated pigment as Extrudate 2 as illustrated in the following Example 6.

5 The composition of Extrudate 2 is:

**Extrudate 2**

Araldite GT6084	61.5g
Antaron V220	18.5g
Irgalite Blue LGID	20g

10 Antaron V220 is an alkylated polyvinylpyrrolidone made by GAF/ISP Chemicals, New Jersey U.S.A..

**EXAMPLE 6**

	<b>Extrudate 2</b>	125g
	Finish WR1101	5g
15	DC 200 Fluid	100 cSt 370g

With the above example 6, it was found that the use of Finish WR1101 contributed to marking particle charging so that the use of an additional charge control agent was not required.

Furthermore, the dispersion strength of the Finish WR1101 was found to be  
20 superior to that of the previously used Elastosil M4640A and it could therefore be used in lesser quantities while still maintaining the desirable dispersion attributes of these materials.

The improvement in dispersion strength is believed to be due to the increased surface activity associated with the amine functional Finish WR1101 compared

to that of the vinyl functional Elastosil M4640A.

A standard print sample for Example 6 demonstrated the effectiveness of the dispersion agent by showing excellent image quality no rivulet formation, high maximum optical density and zero background fog or noise density.

5 The following examples 13 to 15 further illustrate formulations which demonstrate the excellent image quality obtained in the noted electrostatic printer.

The composition of Extrudate 3 is:

**Extrudate 3**

10	Araldite 6084	61.5g
	Antaron V220	18.5g
	Tintacarb 435	20g

Tintacarb is a CI Pigment Black 7 made by Cabot Corporation, Australia.

**EXAMPLE 7**

15	Extrudate 3	120g
	Nuxtra 6% Zirconium	4g
	Elastosil M4640A	120g
	DC 200 Fluid	20 cSt 356g

20 A standard print sample for Example 7 demonstrated the effectiveness of the dispersion agent by showing excellent image quality no rivulet formation, high maximum optical density and zero background fog or noise density.

The composition of Extrudate 4 is:

**Extrudate 4**

Araldite 6084	61.5g
Antaron V220	18.5g
Irgalite Rubine LB4N	20g

5 Irgalite Rubine is a CI Pigment Red 57 made by Ciba-Geigy, Basel Switzerland.

**EXAMPLE 8**

Extrudate 4	120g	
Nuxtra 6% Zirconium	4g	
Elastosil M4640 A	120g	
10 DC 200 Fluid	20 cSt	356g

A standard print sample for Example 8 demonstrated the effectiveness of the dispersion agent by showing excellent image quality no rivulet formation, high maximum optical density and zero background fog or noise density.

The composition of Extrudate 5 is:

15 **Extrudate 5**

Araldite GT6084	61.5g
Antaron V220	18.5g
Monolite Yellow GNA	20g

Monolite Yellow is a CI Pigment Yellow 1 made by ICI Australia, Australia.

20 **EXAMPLE 9**

Extrudate 5	120g
Nuxtra 6% Zirconium	4g

## 18

Elastosil M4640 A		120g
DC 200 Fluid	20 cSt	356g

A standard print sample for Example 9 demonstrated the effectiveness of the dispersion agent by showing excellent image quality no rivulet formation, high 5 maximum optical density and zero background fog or noise density.

**Comparison of particle size reduction effects of Dispersion Additive.**

The formulation examples listed below demonstrate the improved dispersion quality and particle size reduction achieved by using the dispersion additive during the milling stage compared to the same formulation without the 10 dispersion additive for the liquid compositions employing the preferred pigment / resin system, that is Extrudate 2 to Extrudate 5. In the following examples and comparison Extrudate 2 was used. The liquid compositions were prepared by adding the constituents of each example into a ceramic ball jar containing spherical ceramic grinding media and milling for 7 days to prepare a resinous 15 toner. The formulations were then examined for print quality by producing images with the electrostatic printer as previously described.

**EXAMPLE 10**

Extrudate 2		120g
Nuxtra 6% Zirconium		4g
20 Elastosil M4640A		60g
DC 200 Fluid	20 cSt	416g

**EXAMPLE 11**

Extrudate 2		120g
Nuxtra 6% Zirconium		4g
25 Elastosil M4640 A		120g
DC 200 Fluid	20 cSt	356g

## COMPARISON 3

Extrudate 2		120g
Nuxtra 6% Zirconium		4g
DC 200 Fluid	20 cSt	476g

5 Standard print samples for Example 10 and 11 demonstrated the effectiveness of the dispersion agent by showing excellent image quality no rivulet formation, high maximum optical density and zero background fog or noise density, and effectively reducing particle size as detailed in Table 1. Comparison 3 however, demonstrated overall poorer image quality and larger mean particle size

10 diameters as detailed in Table 1. The results here indicate how resin coating the pigment has resulted in maintaining the improved image quality effects associated with the dispersion additive, while also minimising background density and effectively reducing particle size as detailed in Table 1.

Composition	Dispersion Additive	Mean Particle Size Diameters ( $\mu\text{m}$ )	
		weight %	$D(v,0.5)$
Example 11	20	0.79	1.28
Example 10	10	1.15	1.68
Comparison 3	0	1.79	2.23

15 Table 1: Mean diameters from the particle size distribution curves.

The above particle size results were characterised using a Malvern Mastersizer S.  $D(4,3)$  indicates the equivalent spherical volume diameter mean. This value

is biased toward larger particles since volume is a function of the cube of the particle radius.  $D(v,0.5)$  indicates the volume 50% value of the distribution. This differs from  $D(4,3)$  if the volume distribution is skewed.

**Examples of other functional group polysiloxane Dispersion Additives.**

5 Formulations utilising polysiloxanes as dispersing agents for various liquid developer formulations have been investigated. These polysiloxane dispersing agents, possess at least one functional group, for example, a vinyl group, a carboxylic acid group, hydroxyl group or an amine group.

Other liquid composition formulations that utilise different polysiloxane  
 10 dispersion additives that demonstrate similar improved dispersion and image quality, are given below. These formulations are based on utilising one of the preferred Extrudates, Extrudate 2 in the following examples, as the marking particle. The liquid compositions were prepared by adding the constituents of each example into a ceramic ball jar containing spherical ceramic grinding  
 15 media and milling for 7 days to prepare a blue resinous toner. The formulations were then examined for print quality by producing images with the electrostatic printer as previously described.

**EXAMPLE 12**

	Extrudate 2	120g	
20	Nuxtra 6% Zirconium	4g	
	Elastosil M4600A	120g	
	DC 200 Fluid	20 cSt	356g

**EXAMPLE 13**

	Extrudate 2	120g
25	Nuxtra 6% Zirconium	4g
	Finish WR1101	60g

21

DC 200 Fluid	20 cSt	416g
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**EXAMPLE 14**

Extrudate 2	120g	
Nuxtra 6% Zirconium	4g	
5. Elastosil LR 3003/10 A	90g	
DC 200 Fluid	20 cSt	386g

Elastosil M4600A is a polysiloxane having a vinyl functional group, Finish WR1101 is a polysiloxane having an amine functional group, Elastosil LR 3003/10A is a polysiloxane having an hydroxyl functional group, all being made  
10 by Wacker Chemicals, Munich Germany.

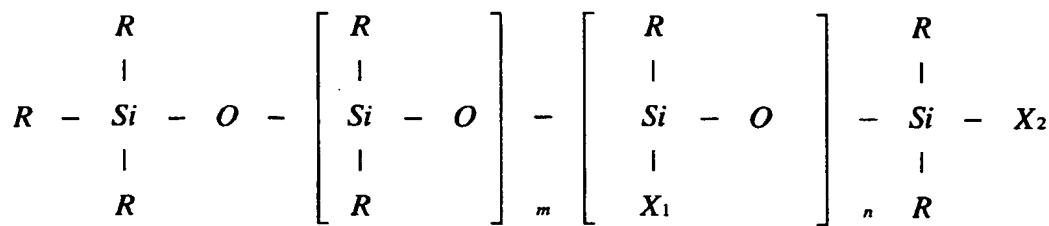
Examples 12 to 14 also demonstrated the effectiveness of different functional group polysiloxane dispersion additives by showing good image quality with no rivulet formation, high maximum optical density and zero background density.

It has also been found that the liquid toner compositions of this invention have  
15 demonstrated great stability over a range of environmental conditions, and hence demonstrated a long shelf-life; as determined by accelerated age testing, viscosity and particle size analysis, and other pertinent test procedures as is known in the art. Excellent resistance to temperature variations, in the range of 20°C to 60°C was exhibited by the liquid developer compositions of this invention, therefore allowing minimal disturbance to the liquid toner stability under possible extreme operational and transportation conditions.

## CLAIMS

1. A liquid toner composition for use in electrostatic printing processes operating within the viscosity range of from 100 to 10,000 mPa.s, the liquid toner comprising:
  - 5 (a) a non-aqueous carrier liquid, the carrier liquid being an electrically non-conductive liquid selected from the group comprising a silicone fluid of straight chained configuration, a silicone fluid of cyclic configuration, a silicone fluid of branched configuration, or a combination thereof having a viscosity in the range of from 0.5 to 1,000 mPa.s.
  - 10 (b) an insoluble marking particle, and
  - (c) a dispersion additive, the dispersion additive comprising a polysiloxane having at least one functional group comprising a radical which introduces an active site into the polysiloxane and wherein the functional group is a radical selected from the group comprising a vinyl group, a carboxylic group, a hydroxyl group, or an amine group,
- 15 whereby the formation of rivulets is minimised during printing with resultant improvement in image quality.
2. A liquid composition as in Claim 1 wherein the polysiloxane dispersion agent is selected from the group comprising a straight chain polysiloxane or a cyclic polysiloxane or a branched polysiloxane, or a combination thereof.
- 20 3. A liquid composition as in Claim 1 wherein the viscosity of the polysiloxane dispersion additive is up to 90,000 mPa.s.
4. A liquid composition as in Claim 1 wherein the polysiloxane dispersion agent is a polysiloxane polymer represented by the following general structure:

23



where R represents an alkyl ( -CH<sub>3</sub>) group or a hydroxyl group ( -OH) and X<sub>1</sub> and X<sub>2</sub> represent functional groups with:

5 (1) Amine functionality ( -NH<sub>2</sub>)

(2) Carboxylic acid functionality ( -COOH)

(3) Vinyl functionality ( -CH=CH<sub>2</sub>)

(4) Hydroxyl functionality ( -OH)

(5) Alkyl functionality ( -CH<sub>3</sub>), but wherein either X<sub>1</sub> or X<sub>2</sub> also contains a functionality selected from (1) to (4) above.

10 (6) An alkyl group containing a functional group selected from (1) to (4) above, with appropriate stoichiometry, ie:

-RX

-RXR

15 -RXRX

-XR

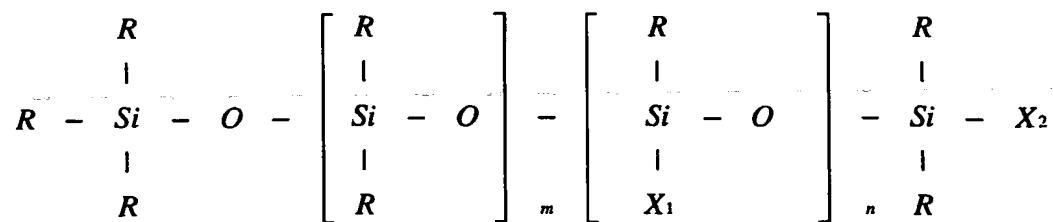
-XRX

-XRXR

where X is a functional group selected from (1) to (4) above and R is an alkyl group.

5. A liquid composition as in Claim 1 wherein the marking particle is selected from the group comprising a pigment, a polymeric resin, ferromagnetic particles and luminescent particles.
6. A liquid composition as in Claim 1 wherein the marking particle concentration is up to 40% by weight.
7. A liquid composition as in Claim 1 wherein the insoluble marking particle 10 is a modified epoxy polymer, the polymer being a reaction product of an epoxy resin and nitrogen bearing polymeric compound.
8. A liquid composition as in Claim 7 wherein the nitrogen bearing polymeric compound is an alkylated polyvinylpyrrolidone.
9. A liquid composition as in Claim 7 wherein a pigment is coated with the 15 modified epoxy polymer.
10. A liquid composition as in Claim 7 wherein the modified epoxy polymer is blended with a pigment and then extruded.
11. A liquid composition as in Claim 1 wherein the liquid composition further includes one or more additional components selected from the group 20 comprising dyestuffs, curing agents, bacteriostats, charge control agents and anti-oxidants.

12. A liquid composition as in Claim 2 wherein the polysiloxane dispersion agent is a polysiloxane polymer represented by the following general structure:



5

where R represents an alkyl ( -CH<sub>3</sub>) group or a hydroxyl group ( -OH) and X<sub>1</sub> and X<sub>2</sub> represent functional groups with:

- (1) Amine functionality ( -NH<sub>2</sub>)
- (2) Carboxylic acid functionality ( -COOH)
- 10 (3) Vinyl functionality ( -CH=CH<sub>2</sub>)
- (4) Hydroxyl functionality ( -OH)
- (5) Alkyl functionality ( -CH<sub>3</sub>), but wherein either X<sub>1</sub> or X<sub>2</sub> also contains a functionality selected from (1) to (4) above.
- (6) An alkyl group containing a functional group selected from (1) to 15 (4) above, with appropriate stoichiometry, ie:

-RX

-RXR

-RXRX

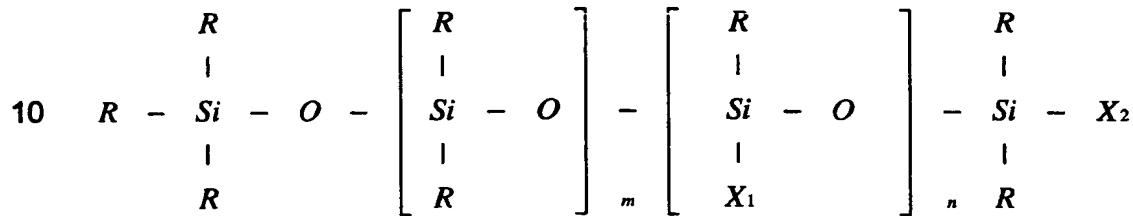
-XR

-XRX

-XRXR

5 where X is a functional group selected from (1) to (4) above and R is an alkyl group.

13. A liquid composition as in Claim 3 wherein the polysiloxane dispersion agent is a polysiloxane polymer represented by the following general structure:



where R represents an alkyl ( -CH<sub>3</sub>) group or a hydroxyl group ( -OH) and X<sub>1</sub> and X<sub>2</sub> represent functional groups with:

- (1) Amine functionality ( -NH<sub>2</sub>)
- 15 (2) Carboxylic acid functionality ( -COOH)
- (3) Vinyl functionality ( -CH=CH<sub>2</sub>)
- (4) Hydroxyl functionality ( -OH)

(5) Alkyl functionality ( -CH<sub>3</sub>), but wherein either X<sub>1</sub> or X<sub>2</sub> also contains a functionality selected from (1) to (4) above.

(6) An alkyl group containing a functional group selected from (1) to (4) above, with appropriate stoichiometry, ie:

5

-RX

-RXR

-RXRX

-XR

-XRX

10

-XRXR

where X is a functional group selected from (1) to (4) above and R is an alkyl group.

## INTERNATIONAL SEARCH REPORT

International application No.

PCT/AU00/01025

## A. CLASSIFICATION OF SUBJECT MATTER

Int. Cl. 7: G03G 9/135; C09D 11/10

According to International Patent Classification (IPC) or to both national classification and IPC

## B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)  
G03G 9/135, 9/12; C09D 11/10Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched  
AU: IPC AS ABOVE

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

DERWENT: WPAT, JPAT

## C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	Derwent Abstract Accession Number 91-067824, Class S06, JP 2-308173 A (CANO) 21 December 1990 abstract	1-13
X	Derwent Abstract Accession Number 91-067825, Class S06, JP 2-308174 A (CANO) 21 December 1990 abstract	1-13
X	Derwent Abstract Accession Number 92-062229, Class S06, JP 4-009860 A (CANO) 14 January 1992 abstract	1-13

Further documents are listed in the continuation of Box C  See patent family annex

* Special categories of cited documents:	
"A" document defining the general state of the art which is not considered to be of particular relevance	"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
"E" earlier application or patent but published on or after the international filing date	"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)	"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art
"O" document referring to an oral disclosure, use, exhibition or other means	"&" document member of the same patent family
"P" document published prior to the international filing date but later than the priority date claimed	

Date of the actual completion of the international search

12 October 2000

Date of mailing of the international search report

16 OCT 2000

Name and mailing address of the ISA/AU

AUSTRALIAN PATENT OFFICE  
PO BOX 200, WODEN ACT 2606, AUSTRALIA  
E-mail address: pct@ipaaustralia.gov.au  
Facsimile No. (02) 6285 3929

Authorized officer

DR. A. TESSEMA

Telephone No : (02) 6283 2271

## INTERNATIONAL SEARCH REPORT

International application No.

PCT/AU00/01025

C (Continuation)

## DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	Derwent Abstract Accession Number 92-062230, Class S06, JP 4-009861 A ( CANO ) 14 January 1992 abstract	1-13
A	DT 2613603 A ( XEROX CORP. ) 28 October 1976, whole document	1-13
A	Derwent Abstract Accession Number 89-126656, Class S06, JP 1-073354 A ( CANO ) 17 March 1989 abstract	1-13
A	Derwent Abstract Accession Number 89-189636, Class S06, JP 1-129261 A ( CANO ) 22 May 1989 abstract	1-13
A	WO 94/17454 A ( RESEARCH LABORATORIES OF AUSTRALIA PTY. LTD. ) 4 August 1994 whole document	1-13
A	EP 347918 A ( KONICA CORPORATION ) 27 December 1989 whole document	1-13
A	US 5384225 ( KUROTORI et al. ) 24 January 1995 whole document	1-13
A	US 5463453 A ( KUROTORI et al. ) 31 October 1995 whole document	1-13

**INTERNATIONAL SEARCH REPORT**  
Information on patent family members

International application No.  
**PCT/AU00/01025**

This Annex lists the known "A" publication level patent family members relating to the patent documents cited in the above-mentioned international search report. The Australian Patent Office is in no way liable for these particulars which are merely given for the purpose of information.

Patent Document Cited in Search Report				Patent Family Member			
DT	2613603	JP	51125503				
WO	9417454	AU	58545/94	EP	680628	EP	680629
		US	5591557	US	5612162	WO	9417453
		CN	1115421	CN	1115422		
EP	347918	JP	2006985	US	5026620		
US	5384225	JP	3033867	JP	3036555		
US	5463453	JP	3068962	JP	3068964	JP	3083073
		JP	3120556	JP	3120557	JP	3120558

**END OF ANNEX**